

5/02

DART AEROSPACE LTD.	Work Order:	22083
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	to 5

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	JK	04.12.08	to
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B2084	EP	04/12/13	5
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B21801	EP	04/12/13	5
4	MV	Fixturing W/O No. <u>WPA</u> Fixturing Inspection last completed <u>04/12/13</u> by EP	EP	04/12/13	5
5	MV	Program Batch No. <u>B22083</u> Double check by JK	EP	04/12/13	5
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/12/14	5
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/12/14	5
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/12/14	5
9	MV	Machine keyway as per dwg D2571 & D2572	EP	04/12/14	5
10	MV	Deburr and remove all machining marks	EP	04/12/14	5
11	MV	Tumble for 20 minutes to remove sharp edges <u>04.12.14</u>	EP	04/12/15	5
12	QC1	Inspect all dimensions to dimension sheets	EP	04/12/15	5
13	QC7	Second inspection	JK	04/12/16	5
14	FP	Acid etch and alodine as per QSI 005 4.1	JK	04-12-16	5
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	JK	05/01/03	5
16	QC3	Inspect Powder Coat	JK	05-01-03	5
17	ST	Identify and Stock.	JK	05-01-03	5
18	AC	Cost / Part 111.10 103.07 Close W/O 112.51 99.53	SAC	05-01-04	5
19	DC	Inspection Level 21	JK	05.01.06	5

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED
02/10/13 RF